

5679 4693

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794693



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794693

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		12-1-08	SPD
430	ASSEMBLE TO STOCK		12-1-08	SP
440	PROOF		12-1-08	SPD
460	CHECK HEADSPACE		12-1-08	SPD
470	DIS-ASSEMBLE ACTION		12-1-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	12-2-08	RZ
475	DRILL AND TAP SIGHT HOLES	DEC 18 2008	12-2-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	12/5/08	
490	MAGNAFLUX BOLT		12-9-08	MR
500	ROLLMARK CALIBER		12/9/08	RT
520	GOFF BLAST BBL / REC		12-11-08	DC
542	APPLY COATINGS (BARREL ACTION)		12/16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-29-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-4-09	RZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

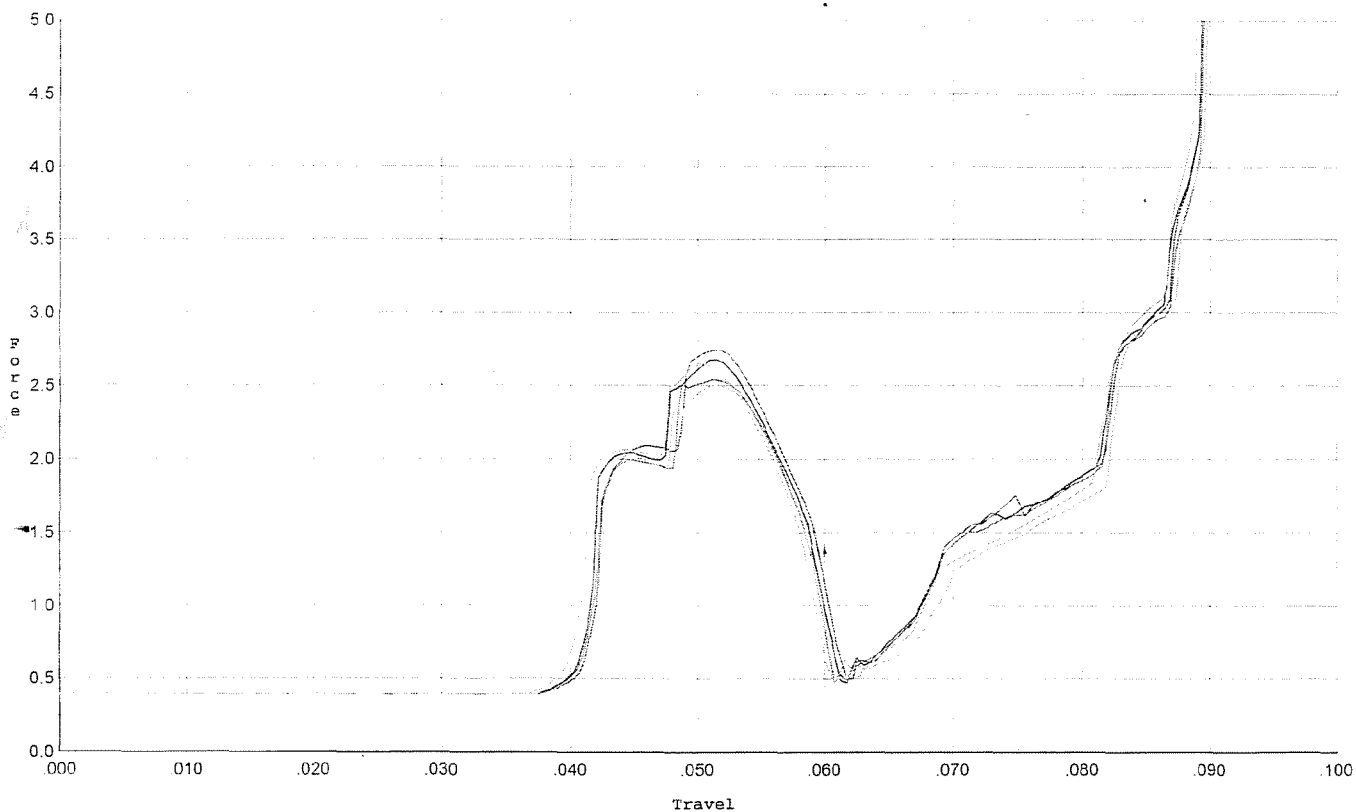
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>3</u> <u>2.5</u>	1-22-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	1-22-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-22-09	W/W
	J) ASSEMBLE STOCK		1-14-09	KTZ
	K) ASSEMBLE SWIVEL STUDS		1-22-09	W/W
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	1-20-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-20-09	W/W
670	FINAL INSPECTION A) HEADSPACE		1-22-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>3.19</u> <u>3.67</u> <u>2.58</u> <u>3.67</u> <u>2.57</u>	1-31	W/W
	C) FUNCTION		1-22-09	W/W
690	PACK		1-23-09	R/R

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs ini +/- .50 lbs



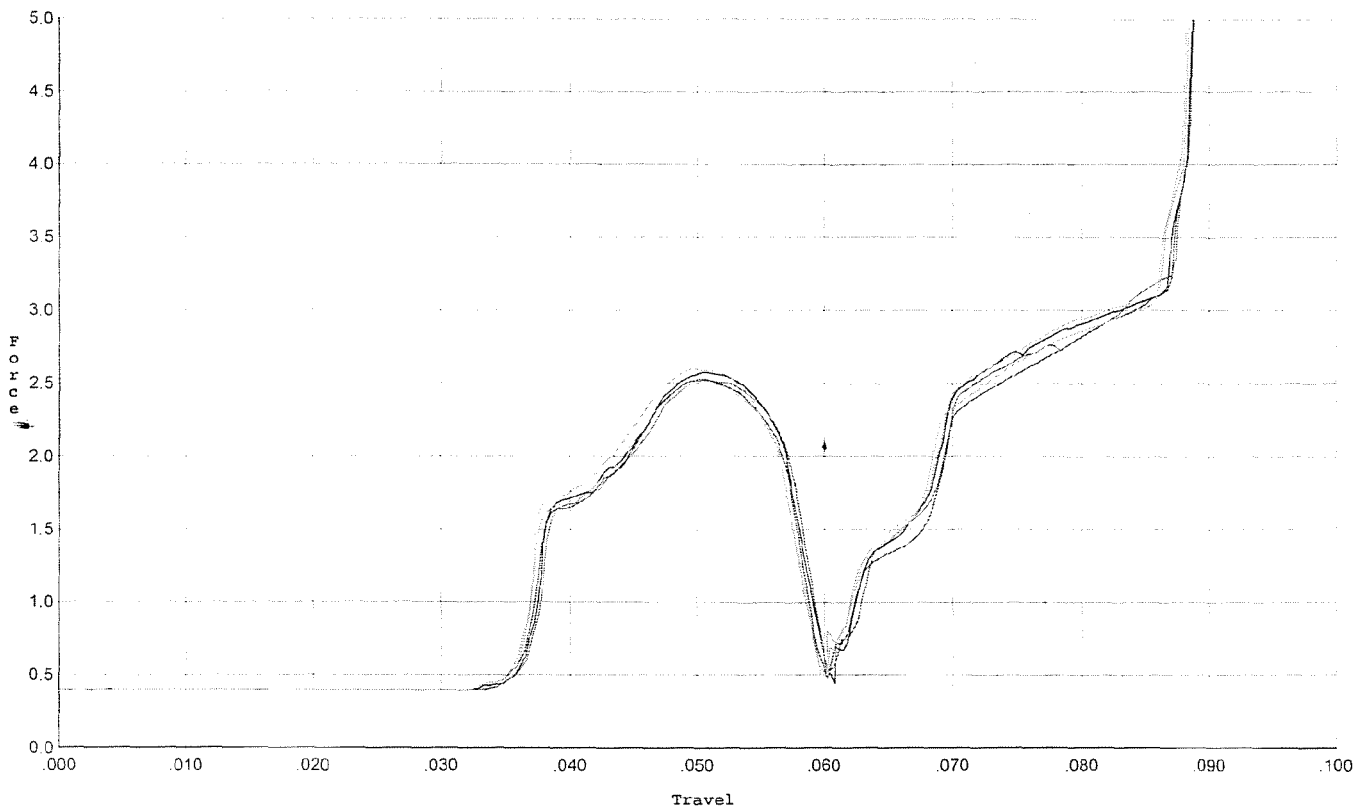
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.744	0.059	0.041	0.037	0.055		Set Trigger
2	2.679	0.059	0.041	0.037	0.055		Set Trigger
3	2.544	0.059	0.041	0.038	0.053		Set Trigger
4	2.503	0.059	0.041	0.038	0.053		Set Trigger
5	2.650	0.058	0.040	0.037	0.055		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs after 50 cycles+/- .50 lbs



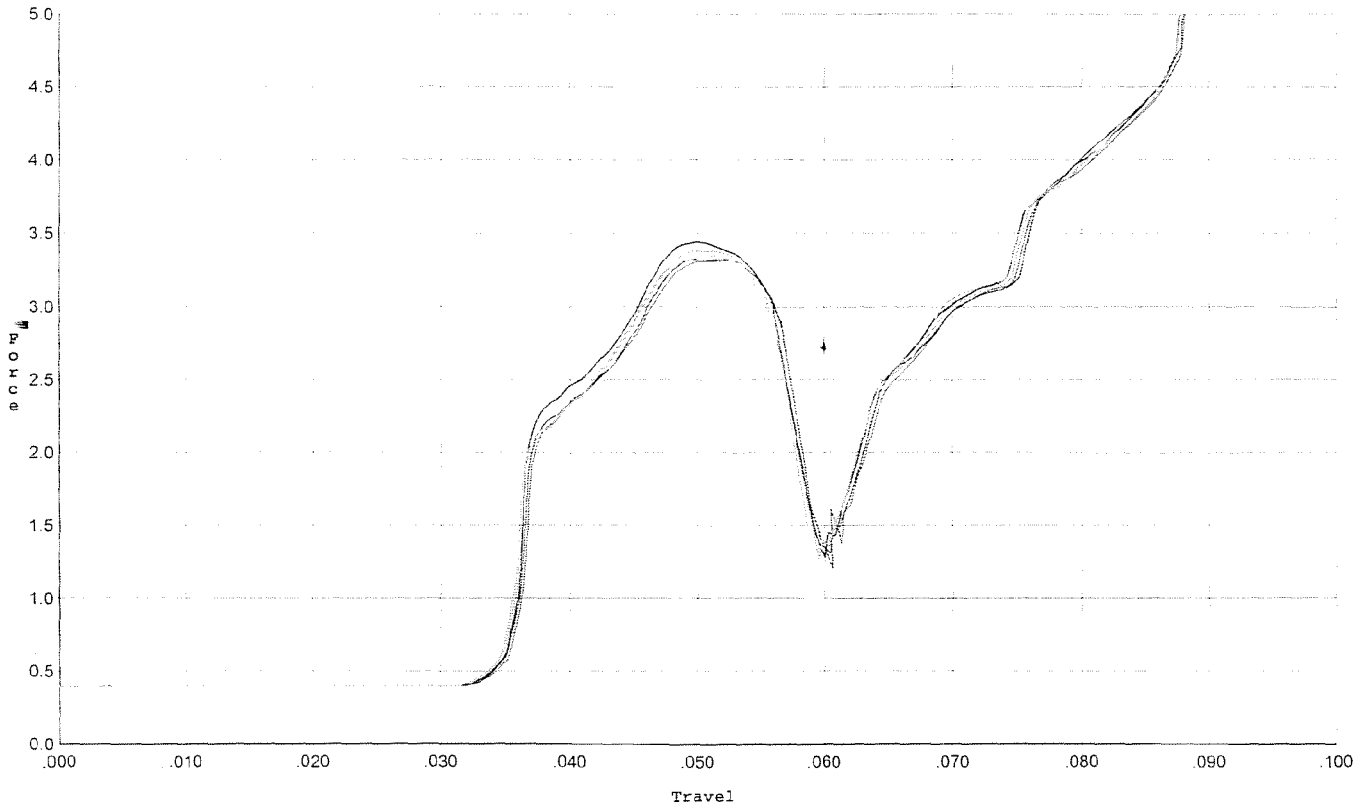
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.057	0.036	0.037	0.058		Set Trigger
2	2.579	0.057	0.036	0.037	0.058		Set Trigger
3	2.524	0.058	0.037	0.037	0.058		Set Trigger
4	2.515	0.058	0.036	0.037	0.059		Set Trigger
5	2.603	0.056	0.036	0.037	0.058		Set Trigger

A. 2.55

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs ini +/- .75 lb



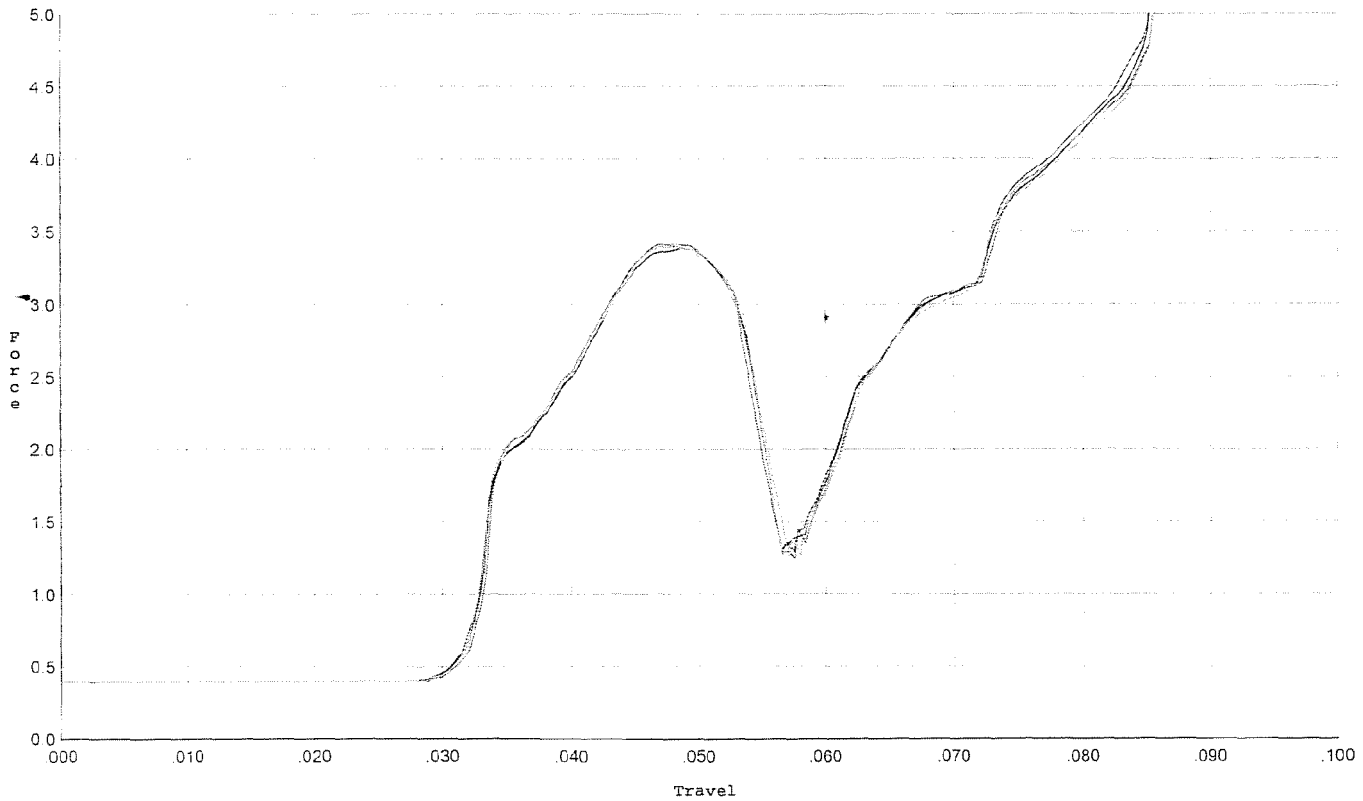
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.057	0.035	0.035	0.074		Set Trigger
2	3.445	0.056	0.035	0.036	0.075		Set Trigger
3	3.329	0.057	0.035	0.036	0.074		Set Trigger
4	3.347	0.056	0.035	0.035	0.074		Set Trigger
5	3.383	0.056	0.035	0.036	0.074		Set Trigger

A-336

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- .75 lb



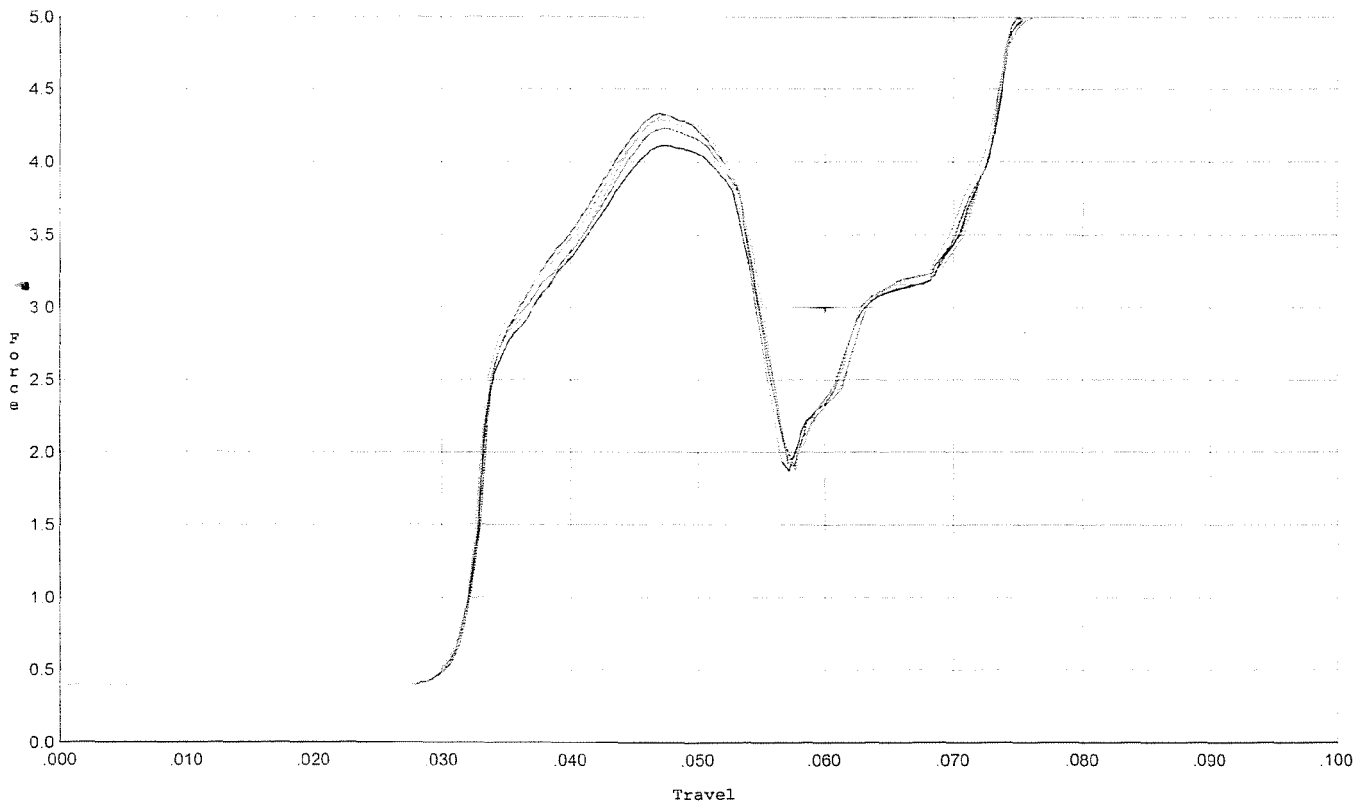
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.416	0.053	0.032	0.035	0.071		Set Trigger
2	3.383	0.054	0.032	0.034	0.072		Set Trigger
3	3.415	0.054	0.032	0.034	0.073		Set Trigger
4	3.393	0.054	0.032	0.035	0.073		Set Trigger
5	3.401	0.054	0.032	0.034	0.072		Set Trigger

A-3-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



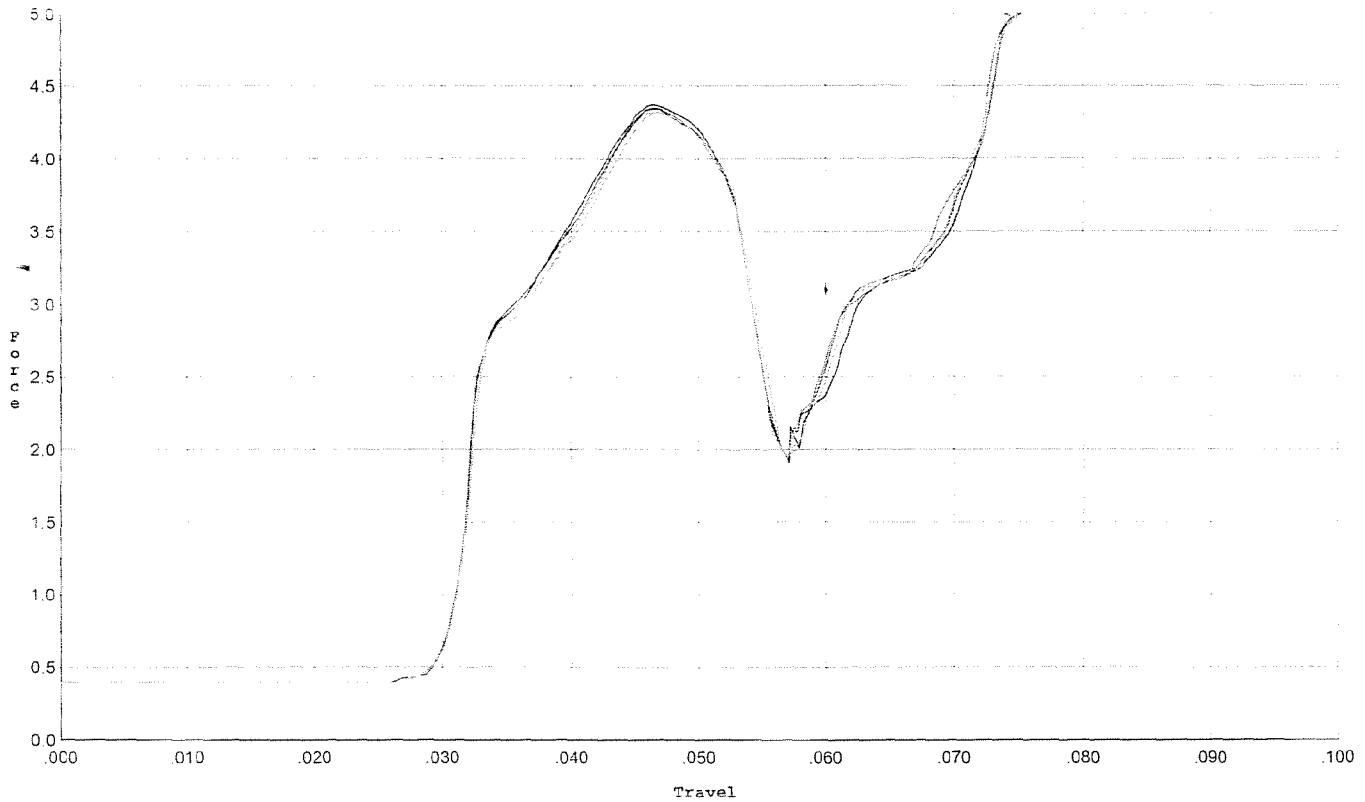
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.334	0.053	0.031	0.033	0.091		Set Trigger
2	4.112	0.054	0.031	0.033	0.089		Set Trigger
3	4.231	0.053	0.031	0.033	0.090		Set Trigger
4	4.291	0.054	0.031	0.033	0.092		Set Trigger
5	4.322	0.054	0.031	0.032	0.093		Set Trigger

A-4.25-

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



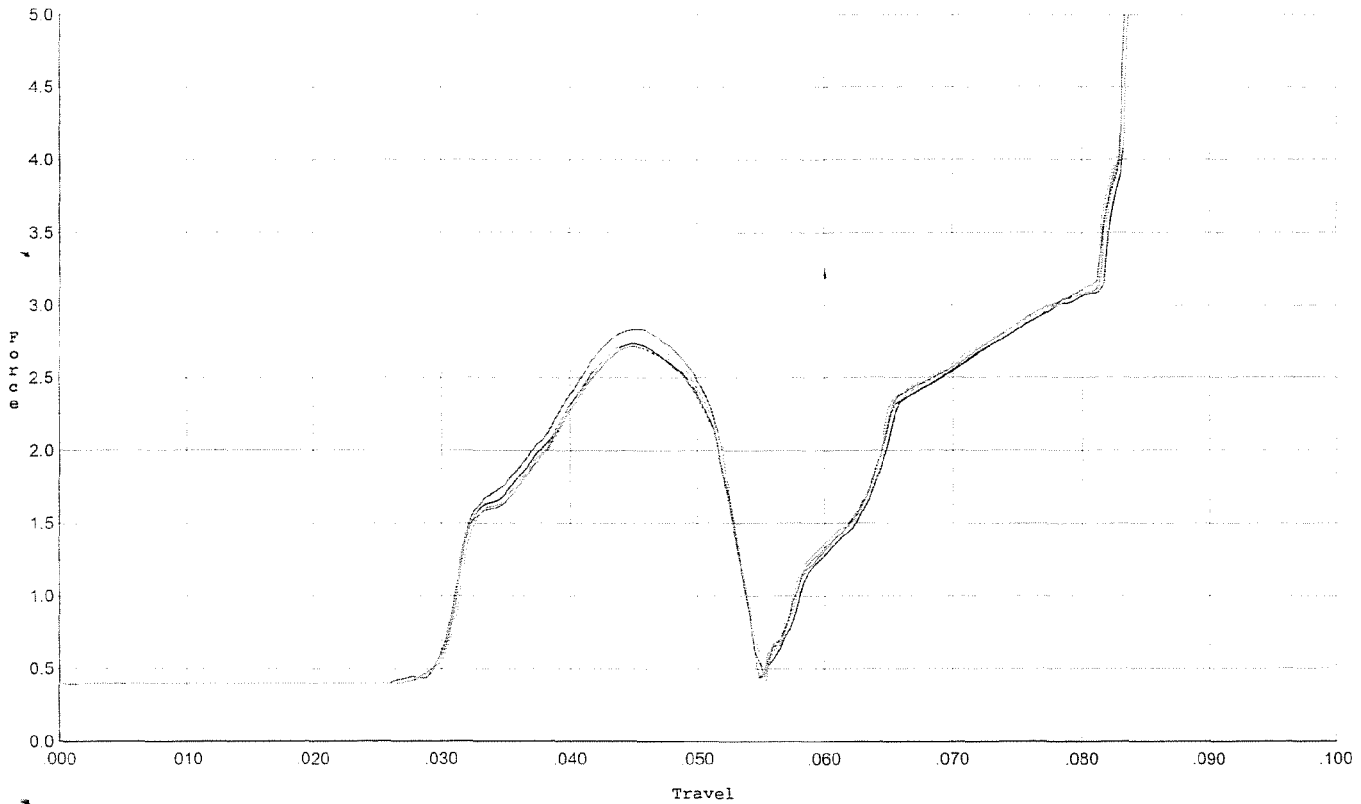
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.340	0.053	0.030	0.032	0.092		Set Trigger
2	4.371	0.053	0.030	0.032	0.092		Set Trigger
3	4.350	0.053	0.030	0.032	0.092		Set Trigger
4	4.315	0.054	0.030	0.032	0.094		Set Trigger
5	4.317	0.053	0.030	0.032	0.092		Set Trigger

A-4.33

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs +/- .50 lb for final test



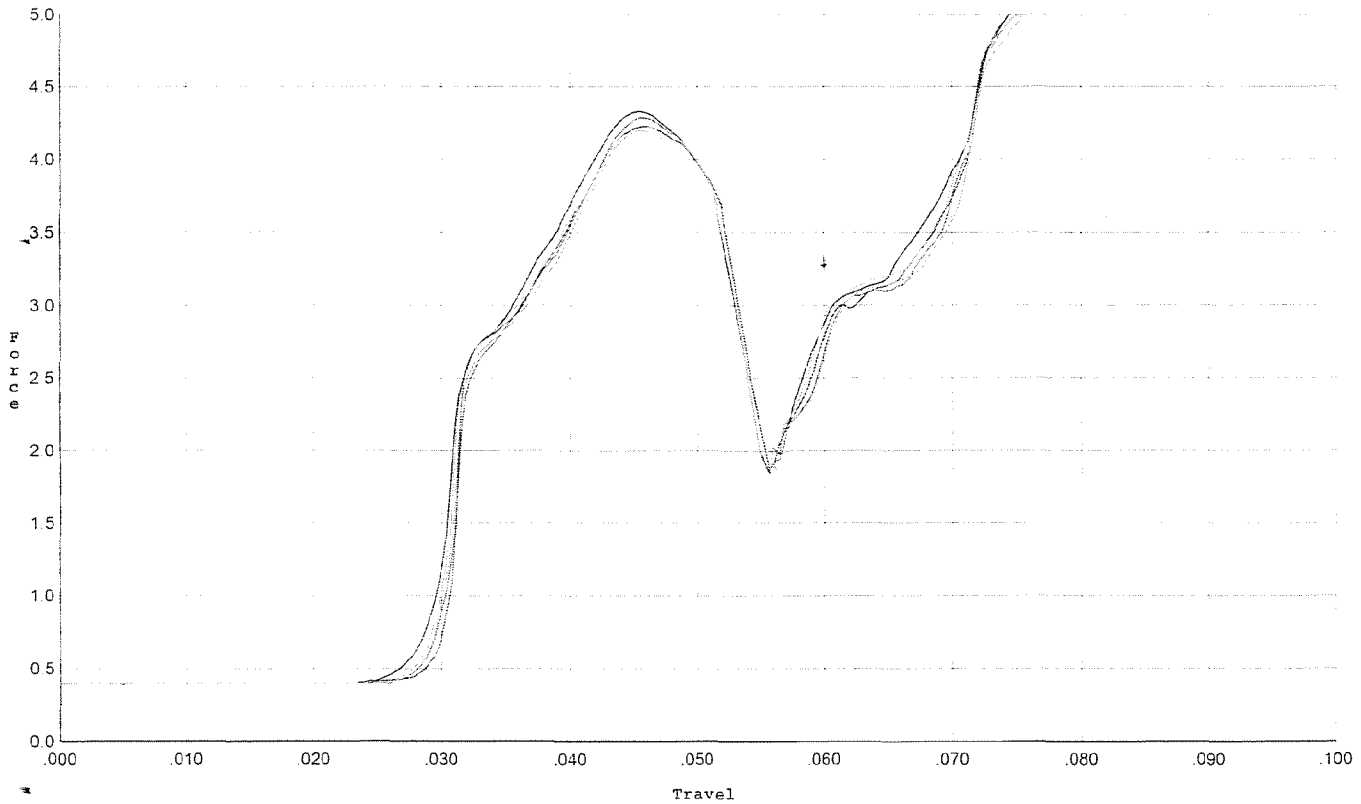
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.836	0.052	0.030	0.035	0.061		Set Trigger
2	2.745	0.052	0.030	0.036	0.060		Set Trigger
3	2.720	0.052	0.030	0.035	0.059		Set Trigger
4	2.773	0.052	0.030	0.036	0.059		Set Trigger
5	2.761	0.053	0.030	0.035	0.060		Set Trigger

A-2-76

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target&accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.226	0.052	0.030	0.032	0.089		Set Trigger
2	4.334	0.053	0.028	0.031	0.093		Set Trigger
3	4.286	0.052	0.029	0.032	0.089		Set Trigger
4	4.236	0.053	0.029	0.031	0.091		Set Trigger
5	4.200	0.052	0.029	0.032	0.089		Set Trigger

A-4.25

